

NON-EUROCOPTER

# Work Order ID 58143



Page 1

April 26, 2010 11:37:45 AM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002  
Attn: NON-EUROCOPTER

5/10/06

HJ for BG 10/05/06

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R: Aluminum Rod 111 311  
M/C 330

3-Grind End Plate flush

210.04.28 / 610.04.27

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58143**

April 26, 2010 11:37:46 AM

Page 2

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

(17) 10.04.23

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

(4) 10.04.23

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

10.04.23

4 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58143

April 26, 2010 11:37:46 AM

Page 3

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	10/04/28			4	0		
180 Large Fab Large Fab	Large Fab  Memo 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M112360 6-Grind End Plate flush 7-Install last rivet as per Dwg.	0.00 0.00				4	0		

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-311 PAR #: \_\_\_\_\_ Fault Category: Large Fns NCR: Yes ☒ No ☐ DQA: 7 Date: 10.05.06  
 Resolution: re work Disposition: re work QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 58143		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.04.29	180	rivet to short on top end, shaver shaved rivets not put in enough, did not sit	<i>[Signature]</i> 0.2212	drill hole in end cap take out shaved rivets and put new rivets and re weld end cap	<i>[Signature]</i> 10.04.29	<i>[Signature]</i> 10/6/04	<i>[Signature]</i> 0.2212	<i>[Signature]</i> 10.04.29
		Properly due to bad installation. R.C. <del>to</del> Not LOA → process. It was the last rivet after welding	<i>[Signature]</i> 0.2212					

NOTE: Date & initial all entries

# Work Order ID 58143

April 26, 2010 11:37:51 AM



Page 4

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

DD

④ 10.05.04

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/6/05/04

④ 10.05.04

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

HLH

BL 10-5-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



[illegible]

Page 5

**Accept**

**Setup Start**

**Stop**



**Start Date:** 4/26/10      **Start Qty:** 4.00

**Cust Item ID:**

**Required Date: 5/03/10      Req'd Qty: 4.00**

**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Draw  
Number**

**Draw  
Rev.**

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3.4 Alum

0.00

[illegible]

## Memo

0.00

## Powder Coating

START TIME: 8:45 AM  
OVEN TEMPERATURE: 320 °F  
FINISH TIME: 9:15 AM

230

Wing Walk as per dwg QSI005 4.4 Baton 1113543 000

49/00



## Memo

0.00

HandFinish

## Hand Finishing

240

QC3- Inspect Part Finish

0.00

**00000000000000000000**

## Memo

0.00

QC

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58143**

April 26, 2010 11:37:56 AM

Page 6

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311  
Location: \_\_\_\_\_

New

C1456 4

Q

C1456 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58143

April 26, 2010 11:37:57 AM

Page 7

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10  
MF  
10-5-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

April 26, 2010 11:37:38 AM

Work Order ID: 58143

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/26/10

Required Date: 5/03/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3-35A		Purchased	No			260 250	Each	64.0000	8.0000			



Bolt

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST353

64

112314

14

114382

50



Bolt

Purchased

No

Each

91.0000

32.0000

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST357

91

114181

6

114330

28

114416

50

4828

7



Bolt

Purchased

No

Each

149.0000

8.0000

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST341

149

114292

149

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

April 26, 2010 11:37:38 AM

Work Order ID: 58143

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/26/10

Required Date: 5/03/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD10	103635	Purchased	No			260 250 AA	Each	0.0000	16.0000		114292	
Washer												
AN960JD416	114030	Purchased	No			260 250 AA	Each	0.0000	64.0000		114076	
Washer												
AN960JD516	114030	Purchased	No			260 250 AA	Each	0.0000	16.0000		1113706	
Washer												
D2230-3		Manufactured	No			260 250 AA	Each	101.0000	16.0000		59	
Lug												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST476

101

56855

101

Each

133.0000

8.0000



Bushing

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST020

133

56892

33

57829

100

April 26, 2010 11:37:38 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 3

April 26, 2010 11:37:38 AM

Work Order ID: 58143

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/26/10

Required Date: 5/03/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2856-400	NR 7.20 <sup>u</sup>	Manufactured	No			260 250 M	f	302.9400	2.4000			
Abraison Strip												

measured  
Siderla

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST403	302.94	
50593	86.94	
56626	216	

50573

D3065-041		Manufactured	No			180 M	Each	38.0000	4.0000			
Step Leg Assembly Hi												

10.04.28

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	38	
55450	8	
56827	30	

4

D3066-1		Manufactured	No			180 M	Each	32.0000	8.0000			
Spacer												

10.04.28

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	32	
56752	32	

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 4

April 26, 2010 11:37:39 AM

Work Order ID: 58143



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 04.03.22 New issue [KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------	--------



End Plate



*Handwritten:* 10.04.27

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA

17

57011

17

Each

17.0000

4.0000



*Handwritten:* 4  
10.04.28  
10.04.27

D3067-1

Manufactured

No



End Plate

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA

17

57011

17

Each

61.0000

8.0000



*Handwritten:* 4  
10.04.27

D3219-1

Manufactured

No



Plate

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA

61

56826

61

*Handwritten:* 8

April 26, 2010 11:37:39 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 26, 2010 11:37:40 AM

Work Order ID: 58143

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3272-1 JLM  
 IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Date: 4/26/10

Required Date: 5/03/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3235-1		Manufactured	No			260 250	Each	23.0000	8.0000			

Mounting Lug

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST471	23	
	55315	23	

D3272-1	Manufactured	No				110	Each	12.0000	4.0000			
Step												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA 358145	12	
	57848	12	

D3278-041	Manufactured	No				260 250	Each	23.0000	4.0000			
Support Assembly												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST471	23	
	55318	23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 26, 2010 11:37:40 AM

Work Order ID: 58143

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Comments: IPP Rev: A 04.03.22 New issue KJ/RF  
IPP Rev: B 07-06-09 Added D3272-1 JLM  
IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by: EC

Start Date: 4/26/10

Required Date: 5/03/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------	--------

DSI 9410-011

Manufactured

No



Step Modification

*Handwritten: Heli-Access*

*Handwritten: 250*

2.0000



*Handwritten: 5845 4/26/10 (4)*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

FG

57038

2

2

MS20600-AD4W4

Purchased

No



Rivets

*Handwritten: 180, 180, 180*

863.0000

64.0000



*Handwritten: 4/10.04.28*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST321

863

113368

363

114181

500

MS21042L3

Purchased

No



Nut

*Handwritten: 260, 250*

996.0000

8.0000



*Handwritten: 4/10/5/6 (4)*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST300

996

113537

46

113644

950

*Handwritten: M113644*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April 26, 2010 11:37:40 AM

Work Order ID: 58143



Parent Item: D350-591-311



Parent Item Name: Heli-Access-Step, Long LH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3272-1 JLM  
 IPP returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L4		Purchased	No			250	Each	1,306.000	32.0000			
						250						
Nut												

## Warehouse Location

### Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

804

113422

112

114108

684

9063

8

Main Warehouse

ST463

500

114416

500

MS21042L5

Purchased

No



Nut

## Warehouse Location

### Main Warehouse

ST300

822

113523

26

113537

100

114108

196

114437

100

114449

400

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>9P</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	* REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042; INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

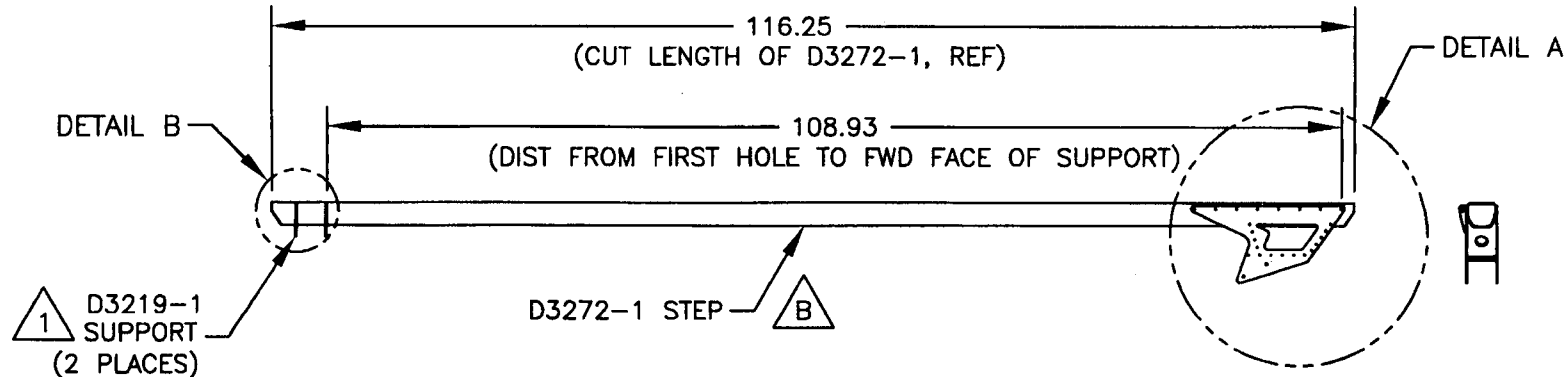
*58143*

Copyright © 2004 by DART AEROSPACE LTD

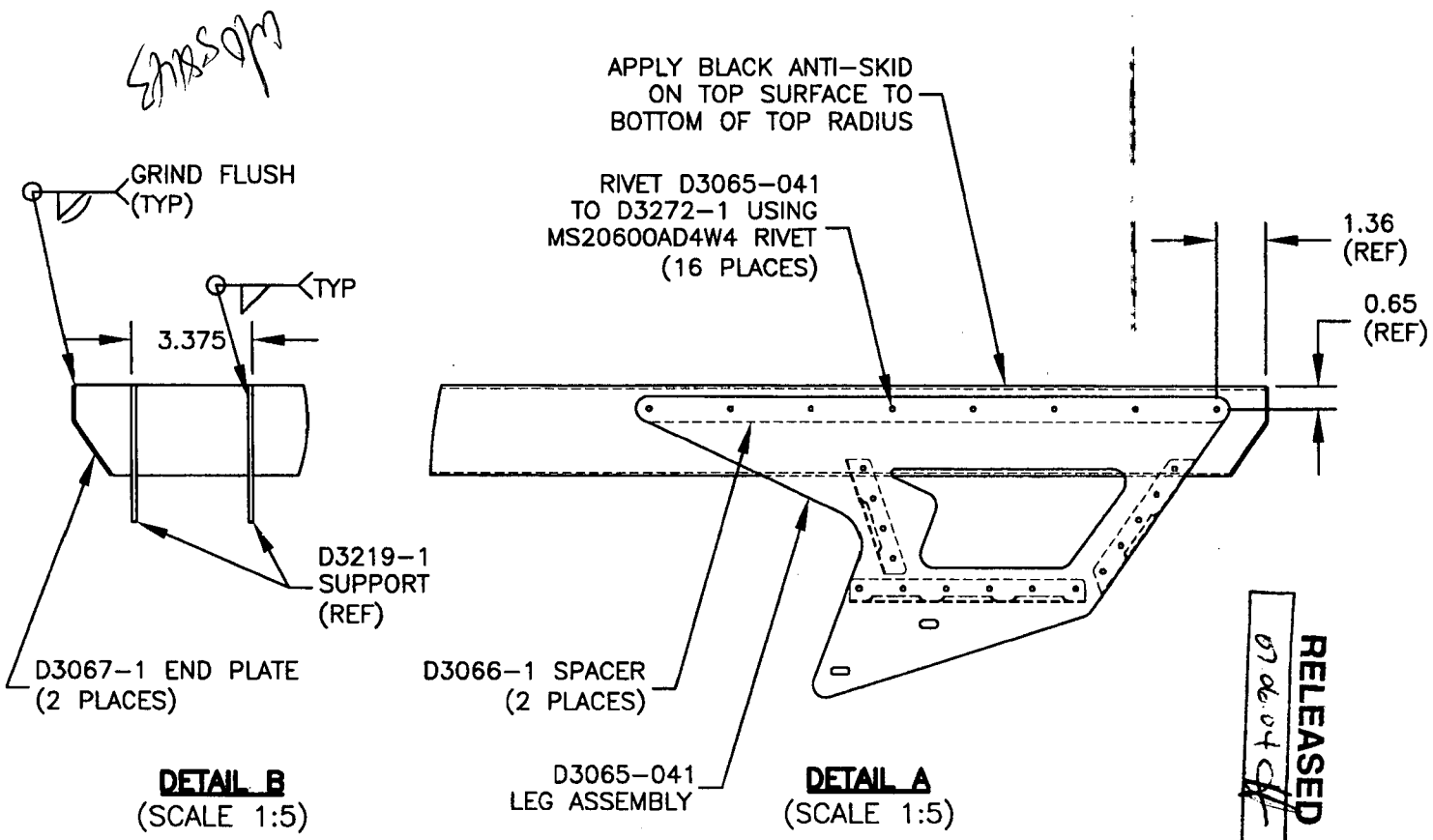
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN	AP	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**

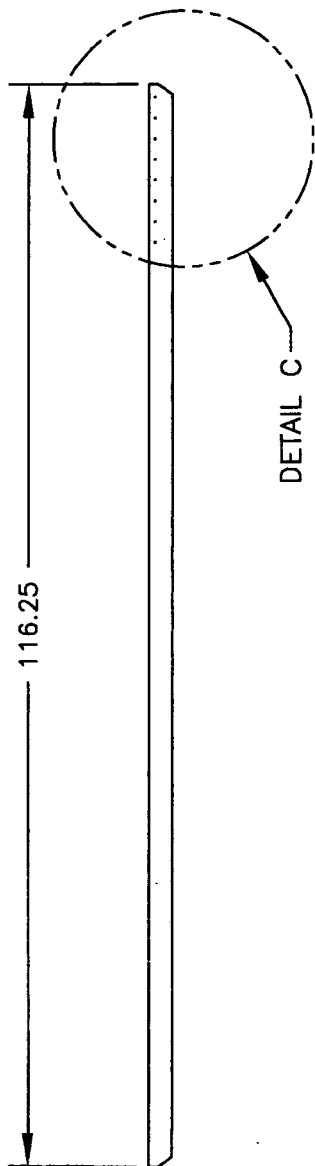


THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2004 by DART AEROSPACE LTD



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

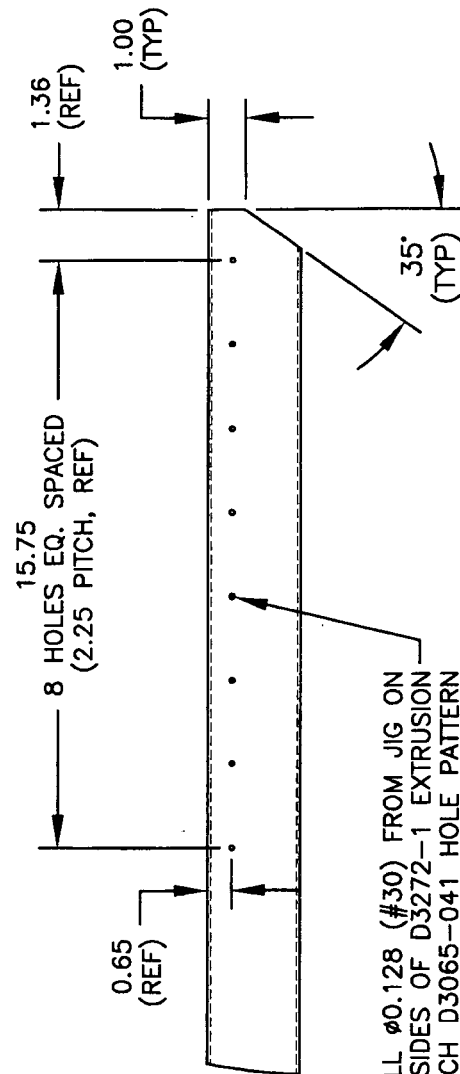


DETAIL C

**B** **D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

*W.D. 07/05/18*



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step Long Step High Skid LH
	X							D350-591-212	Heli-Access-Step Long Step High Skid RH
		X						D350-591-213	Heli-Access-Step Short Step High Skid LH
			X					D350-591-214	Heli-Access-Step Short Step High Skid RH
				X				D350-591-215	Heli-Access-Step Short Step Low Skid LH
					X			D350-591-216	Heli-Access-Step Short Step Low Skid RH
						X		D350-591-311	Heli-Access-Step Long Step High Skid LH
							X	D350-591-312	Heli-Access-Step Long Step High Skid RH
1								D3070-041	STEP/ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP/ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP/ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP/ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP/ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP/ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP/ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP/ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI-9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-31-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries